

D2230-3
148845
151888

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Revision ID:

Item Name: Mounting Lug

Start Date: 7/11/2016 Start Qty: 80.00 ***80***

Cust Item ID:

Required Date: 7/18/2016 Req'd Qty: 80.00 ***80***

Customer:

Reference:

Approvals: Process Plan: DAS 13 9-89 Date: **AUG 23 2016** Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2230	Rev G								
110	Outsource process - Machining	0.00							
110	HAAS CNC VERTICAL MACHINING #1								
Outsource5	Memo	4,479.82							
Outsource process - Machining	Issue P/O to Metec : 33388 Machine as per dwg C of C is required								
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	0.27							
Packaging	Ensure C of C is attach								
130	QC6- Inspect dimensions to drawing	0.00							
130									
QC	Memo	0.27							
Quality Control									

80
AUG 23 2016
DAS 13 9-89

80 x Sp/6 9-23

80
OCT 03 2016
DAS 38 9-89

~~*148845*~~

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Revision ID:

Item Name: Mounting Lug

Start Date: 7/11/2016 Start Qty: 80.00

80

Cust Item ID:

Required Date: 7/18/2016 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.27							
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.13							
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.27							

~~*148845*~~

Page 3

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NS1

Stop

NS2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.13

Quality Control

OCT 03 2016

180

Identify as per dwg & Stock Location: 51521

0.00

180

Packaging

Memo

0.13

Packaging

DAS
80 6
9-89

OCT 14 2016

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

1.33

Quality Control

DAS
21
9-89

OCT 14 2016

148845 was closed
+ costed
U 61014 pulled 02230-3P
on 151885
but closed under
148845

Parent Item: D2230-3

Parent Item Name: Mounting Lug

~~*148845*~~
 D2230-3

Start Date: 7/11/2016

Required Date: 7/18/2016

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP D00.05.18 Added inspection level 8, and removed P/O for powder
 coatEC IPP REV :E NEW FOLIO # 10-05-
 25 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P		Purchased	No				Each	0.0000		80			
D2230-3P									**	80x			
Lug													
D2423		Manufactured	No				f	516.6223		5.751579			
D2423									**				
Lug Extrusion													

Location

Metec

127892

131451

148835

Loc Qty

516.6222907

38.9964647

125.625826

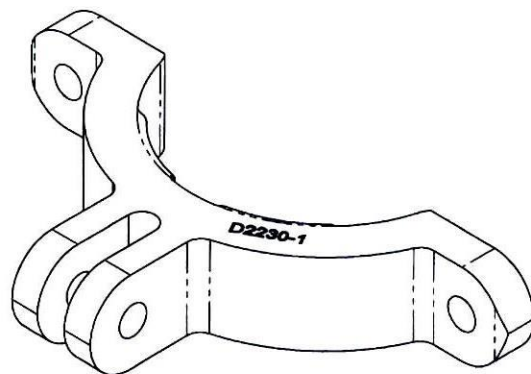
352

Loc Code

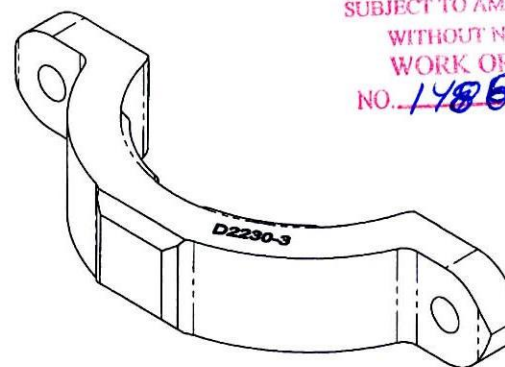
13148835

 DAS
 13
 9-89

AUG 23 2016



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 148895 MLJ

16-07-27

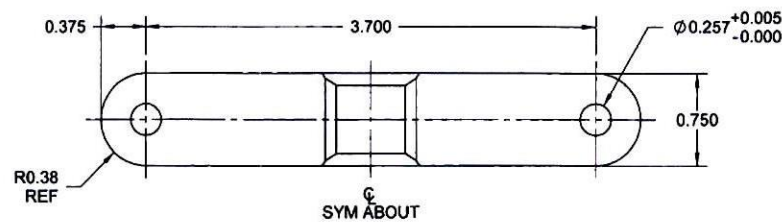
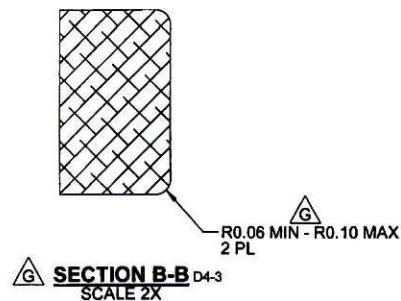
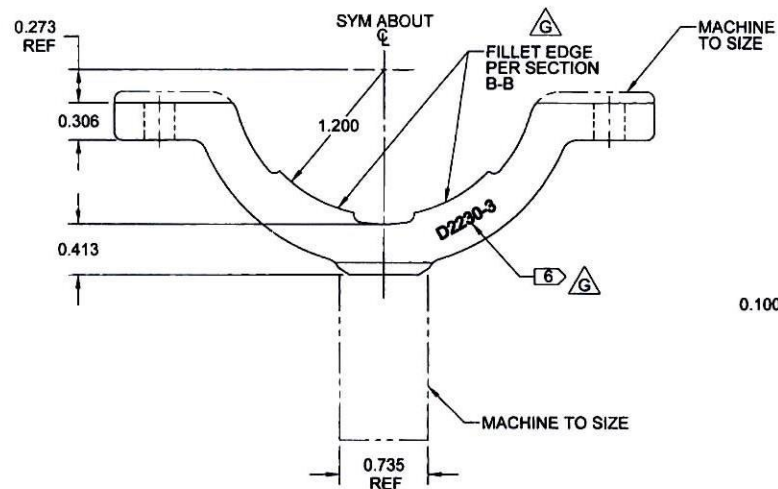
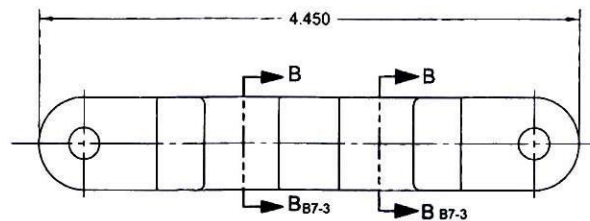
RELEASED
09/01/16

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2230 REV. G SHEET 1 OF 3 TITLE MOUNTING LUG SCALE NTS COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	09.01.16		



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs



D2230-3 MOUNTING LUG

RELEASED
09/06/23

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORD

Purchase Order ID PO3

Purchase Order Date 8/23/2

PO Print Date 8/23/2

Page Number 2 of 3

Order From :

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

VC-MET003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613 678 3957

Buyer

Chantal Lavoie

Customer POID

Customer Tax

10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

Ship To Contact

Ship To Phone

Ship Via:

Dart Truck

Ship Acct:

3

D2230-3P

Lug

9/8/2016 FN

Yes

9/8/2016

80.00

Each

\$13.80

\$1,104.00

AS PER DWG D2230 REV. G
B148845

ALODINE AND PAINT AS PER QSI 005

5016-9-23

Line Total:

\$1,104.00

4

D2230-3P

Lug

9/16/2016 FN

Yes

9/16/2016

180.00

Each

\$13.80

\$2,484.00

AS PER DWG D2230 REV. G
B149711

ALODINE AND PAINT AS PER QSI 005

Line Total:

\$2,484.00

Note:

8/23/2016



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.:

21401

Date:

Sep 20, 2016

Page:

1

Sold to:

Dart Aerospace Ltd.

Att. Linda Lacelle
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7

Ship to:

Dart Aerospace Ltd.
Att. Linda Lacelle
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7

Order No.: 33388

Sold By: VanDenYssel, David

Shipped By: your truck

Ship Date: Sep 20, 2016

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-3 Mounting Lug as per drawing D2731 Rev.C	Each	48		
D3394-1 Lug Assembly as per drawing D3394-1 Rev.B	Each	48		
D2230-3 Mounting Lug as per drawing D2230-3 Rev.G Alodine and Paint as per QSI 005	Each	80	80	
D2230-3 Mounting Lug as per drawing D2230-3 Rev.G Alodine and Paint as per QSI 005	Each	180	180	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				

Received by _____

Thank you for your order!



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
80	D2230-3	Lug Paint 20559	33388
180	D2230-3	Lug Paint 20559	33388

MATERIAL: supplied by DART B148835

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, September 20, 2016

Location/Lot Activity

Friday, October 14, 2016 9:52:30 AM

Page 1 of 1

Criteria : All Items All Locations Lot: 148845 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Account Value Change	D2230-3 / Mounting Lug	Main Warehouse		Laje01		4.0000		4.0000		
		ST521			10/5/2016	-4.0000	148845	-4.0000		(\$44.25)
		Main Warehouse		Laje01		4.0000		4.0000		
		ST521			10/5/2016	4.0000	148845	4.0000		\$44.25
								0.0000		\$0.00
Issue	D2230-3 / Mounting Lug	Main Warehouse	150575	QUIR01		82.0000		80.0000		
		ST521			9/19/2016	-36.0000	148845	-36.0000		(\$398.29)
		Main Warehouse	150576	QUIR01		46.0000		44.0000		
		ST521			9/19/2016	-40.0000	148845	-40.0000		(\$442.54)
		Main Warehouse	148506	QUIR01		84.0000		4.0000		
		ST521			10/5/2016	-20.0000	148845	-4.0000		(\$44.25)
								-80.0000		(\$885.08)
	D2230-3P / Lug	Main Warehouse	148845	PLOU01		80.0000		80.0000		
		ST			9/13/2016	-80.0000	148845	-80.0000		(\$841.69)
								-80.0000		(\$841.69)
PO Receipt	D2230-3P / Lug	Main Warehouse	PO33008	PLOU01		0.0000		0.0000		
		ST			9/13/2016	80.0000	148845	80.0000		\$841.69
		Main Warehouse	PO33388	PLOU01		180.0000		0.0000		
		ST			9/23/2016	80.0000	148845	80.0000		\$841.69
								160.0000		\$1,683.38
WIP Receipt	D2230-3 / Mounting Lug	Main Warehouse	148845	Laje01		2.0000		0.0000		
		ST521			9/19/2016	80.0000	148845	80.0000		\$885.08
								80.0000		\$885.08